

# Work Order ID 74441

Thursday, September 29, 2011 2:41:35 PM

Page 1

Item ID: D3286-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Doubler

Start Date: 9/29/2011 Start Qty: 80.00

Cust Item ID:

Required Date: 10/20/2011 Req'd Qty: 80.00

Customer:

Reference:

Approvals:

Process Plan: M.L.J.

Date: 9/29/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3286

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3286

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B11-10-7



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-10-7

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Subtotal



Subtotal

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID:	D3286-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler					
Start Date:	9/29/2011	Start Qty:	80.00		Cust Item ID:	
Required Date:	10/20/2011	Req'd Qty:	80.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE  Memo Form as per Dwg D3286	0.00  0.00							
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		SB 11/10/17					
150  Packaging Packaging	Identify as per dwg & Stock Location <u>LG</u>  Memo ***STOCK IN SKIDTUBE CELL***	0.00  0.00		5 11/10/17		counts 			
						11/10/17			

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Item ID: D3286-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 9/29/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 10/20/2011 Req'd Qty: 80.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/18

MF 11-10-18

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Thursday, September 29, 2011 2:41:42 PM

Page 1

Work Order ID: 74441

Parent Item: D3286-1

Parent Item Name: Doubler





Start Date: 9/29/2011

Required Date: 10/20/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP A 04.07.14 New issue KJ/JLM  
IPP Rev:B Now on Waterjet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	144.4000	0.0749	6.307368	6.5		
304/316 0.125 Sheet											B11-10-6		

Location

Loc Qty

Loc Code

MAT020

144.4

117494

16.4

119006

64

119048

64

119006

86

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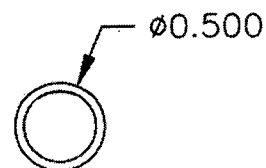
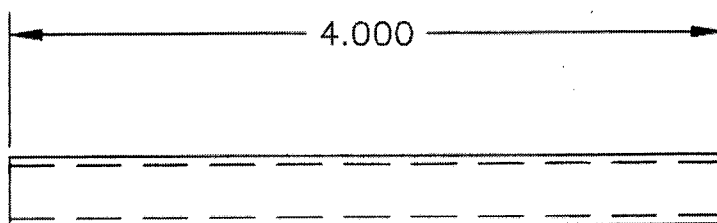
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3286	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1



**D3286-3 SPACER**

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL  
(REF DART SPEC. M304TRO.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
04.06.22 *#*

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**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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